

Work Order ID 58550

Tuesday, May 11, 2010 9:50:08 AM



Page 1

Item ID: D3219-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/11/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-5-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3219

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3219 ☐ Dwg Rev: *A* ☐ Prog Rev: *A*

B 10-5-11

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-5-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 closely

counted
(96)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1-Debur if necessary.

0.00

0.00

= 7 m-l

10/05/12

96x

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8.06.12

96x

25019

150



Packaging

Packaging

Identify as per dwg & Stock Location: WPS

Memo

0.00

0.00

10.05.12

96

f

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Item Name: Plate

Start Date: 5/11/2010 Start Qty: 80.00

Required Date: 5/13/2010 Req'd Qty: 80.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13
ME
10-5-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 11, 2010 9:50:07 AM

Page 1

Work Order ID: 58550



Parent Item: D3219-1



Parent Item Name: Plate

Start Date: 5/11/2010

Required Date: 5/13/2010

Comments: IPP A 04.04.19 New issue KJ/JLM
ESR B 06.05.25 Waterjet EC

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	185.2500	0.0964			



6061-T6 .125 Sheet



B10-5-11

Location

Loc Qty

Loc Code

MAT21

185.25

112476

19.2

113424

6.05

113608

96

114352

64

112476

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	58550
Description: Plate		Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	.319	✓			
2.293	+/-0.005	2.292	✓			
2.965	+/-0.010	2.963	✓			
0.566	+/-0.010	.566	✓			
0.375	+/-0.010	.375	✓			
R0.125	+/-0.010	.125	✓			
13.9°	+/-0.5°	13.9°	✓			

Measured by:	B
Date:	10-5-11

Audited by:	S
Date:	10/05/11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

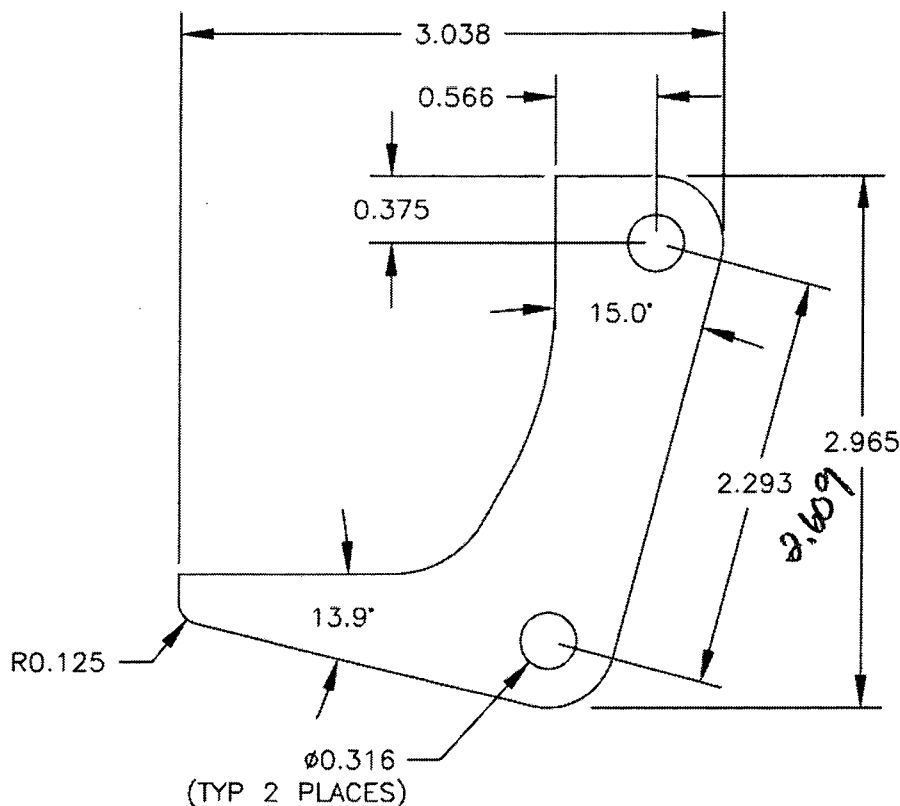
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10	TITLE PLATE		SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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